

DART AEROSPACE LTD		Work Order:	24459
Description: Step Weldment Assembly		Part Number:	D3438-042
Dwg: D3438 Rev. A		Qty:	2
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	U	05-10-06	2																				
2	WA	Cut D2244 to 79.63" at 34° as per Dwg D3438 Batch: B20454	PD	05-10-11	2																				
3	WA	Deburr ends	PD	05-10-12	2																				
4	WA	Inspect for foreign objects as per QSI 024	PD	05-10-12	2																				
5	WA	Weld using DT8343 as per Dwg D3438 Pick: <table><tr><td><u>Qty</u></td><td><u>Part Number</u></td><td><u>Description</u></td><td><u>Batch</u></td></tr><tr><td>2</td><td>D2561</td><td>Lug Plate</td><td>B23179</td></tr><tr><td>2</td><td>D2564</td><td>Mounting Angle</td><td>B23452</td></tr><tr><td>2</td><td>D2673-34</td><td>End Cap</td><td>B23231</td></tr><tr><td>A/R</td><td>N/A</td><td>Aluminum Rod</td><td>M18247 / M15634</td></tr></table>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	2	D2561	Lug Plate	B23179	2	D2564	Mounting Angle	B23452	2	D2673-34	End Cap	B23231	A/R	N/A	Aluminum Rod	M18247 / M15634	PD	05-10-12	2
<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>																						
2	D2561	Lug Plate	B23179																						
2	D2564	Mounting Angle	B23452																						
2	D2673-34	End Cap	B23231																						
A/R	N/A	Aluminum Rod	M18247 / M15634																						
6	WA	Grind	PD	05-10-12	2																				
7	QC9/5	Inspect welding and work to Step 6	ML	05-10-17	2																				
8	FP	Acid etch and Alodine as per QSI 005 4.1	ML	05-10-17	2																				
9	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	ML	05-10-17	2																				
10	FP	Wing Walk as per Dwg 3438 and QSI 005 4.4 Mask off 0.5 each side of D2561 lugs	ML	05-10-17	2																				
11	QC3	Inspect Powder Coat and Wing Walk	CL	05-10-20	2																				
12	ST	Identify and Stock	CL	05-10-20	2																				
13	AC	Cost / part: 138.60	SUS	05-10-21	2																				
14	DC	Close W/O 138.60 Inspect Level 21	CL	05-10-20	2																				

Rev	Date	Change	Revised By	Approved
A	05.05.18	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED
15-05-19

ADJ 0000043

500.0583
95.50
JL
05/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/18/20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



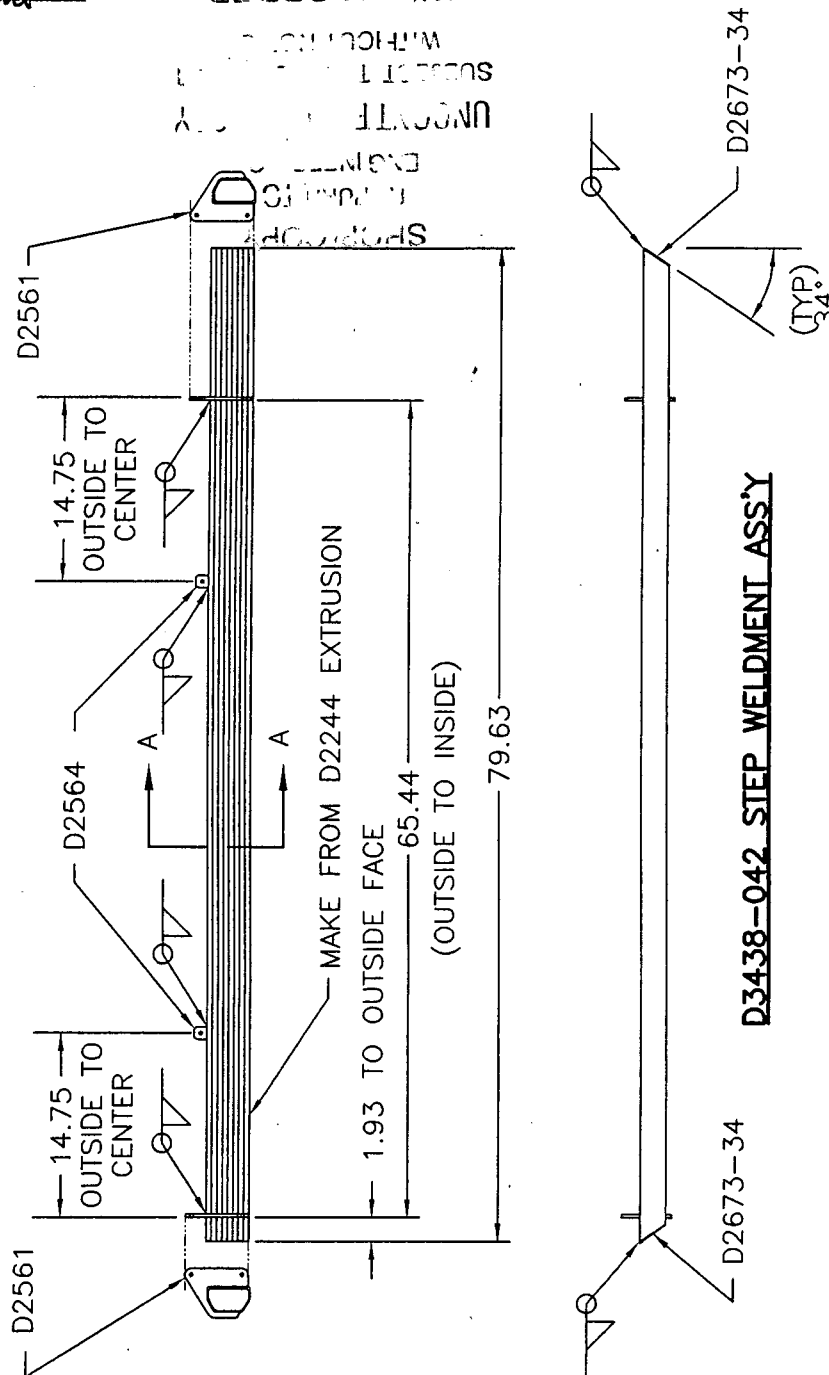
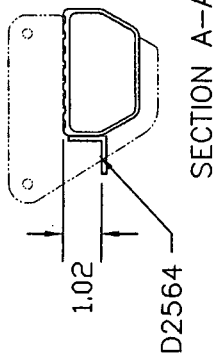
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3438	REV. A SHEET 1 OF 1
DATE 05.05.09	TITLE STEP WELDMENT ASSEMBLY		SCALE 1:1
A	05.05.09	NEW ISSUE	

RELEASED

05.05.22 *[Signature]*

WORK ORDER

UNQUOTE
SHEET 1
SUBJECT 1
WITH CHG NO.



D3438-042 STEP WELDMENT ASS'Y

NOTES:

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1
WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 05, 2005
03:06 pm

Work Order No : 0024459
Project Name : D3438-042
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3438-042
Description : Step Weldment Assembly
Manufactured : Yes
Amount Req'd : 2
Amount Done : 0
Start Date : 10-05-05
Est Finish Date : 10-19-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00